

Work Order ID 66562

Tuesday, February 22, 2011 10:02:05 AM

Page 1

Item ID: D4149-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug Plate, Aft

Start Date: 2/23/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 1-02-22 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4149

B

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: B

Dwg Rev: B

Deburr as required

B 11-2-22

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



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Process Plan:

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Tooling:

Date:

QC:

Date:

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Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/22



150

Identify as per dwg & Stock Location: 133

0.00



Packaging

Memo

0.00

Packaging

11/2/22

sl 20

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/23

Pl 11-02-23

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Picklist Print

Tuesday, February 22, 2011 10:02:02 AM

Page 1

Work Order ID: 66562



Parent Item: D4149-1



Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 2/23/2011

Required Date: 3/9/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	46.5800	0.1355	1.141053			



304/316 0.125 Sheet



1811-2-22

Location

Loc Qty

Loc Code

MAT

46.58

116623

46.58

116623

(8)

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DART AEROSPACE LTD		Work Order: 116562
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	X		V B02	
Ø0.191	+0.005/-0.001	.192	X		V	
Ø0.257	+0.006/-0.001	.258	X		V	
Ø0.38	+0.006/-0.001	.379	X		V	
0.380	+/-0.010	.382	X		V	
0.469	+/-0.010	.473	X		V	
0.310	+/-0.010	.311	X		V	
0.750	+/-0.010	.756	X		V	
3.25	+/-0.030	3.253	X		V	
0.65	+/-0.030	.654	X		V	
0.63	+/-0.030	.630	X		V	
5.46	+/-0.030	5.454	X		V	
3.80	+/-0.030	3.799	X		V	
2.13	+/-0.030	2.128	X		V	
1.313	+/-0.010	1.311	X		V	
0.625	+/-0.010	.627	X		V	
0.375	+/-0.010	.370	X		V	
1.175	+/-0.010	1.173	X		V	
0.752	+/-0.010	.750	X		V	
1.588	+/-0.010	1.587	X		V	
1.587	+/-0.010	1.586	X		V	
11.15	+/-0.030	11.156	X		PRO WS1802	
0.750	+/-0.010	.758	X		V	
1.55	+/-0.030	1.553	X		V	
1.12	+/-0.030	1.135	X		V	
8.42	+/-0.030	8.425	X		PRO WS1802	
2.70	+/-0.030	2.70	X		V	
0.125	+/-0.010	.118	X		V	

Measured by: RB	Audited by: S	Preliminary Approval: N/A
Date: 11-2-22	Date: 11/02/22	Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	

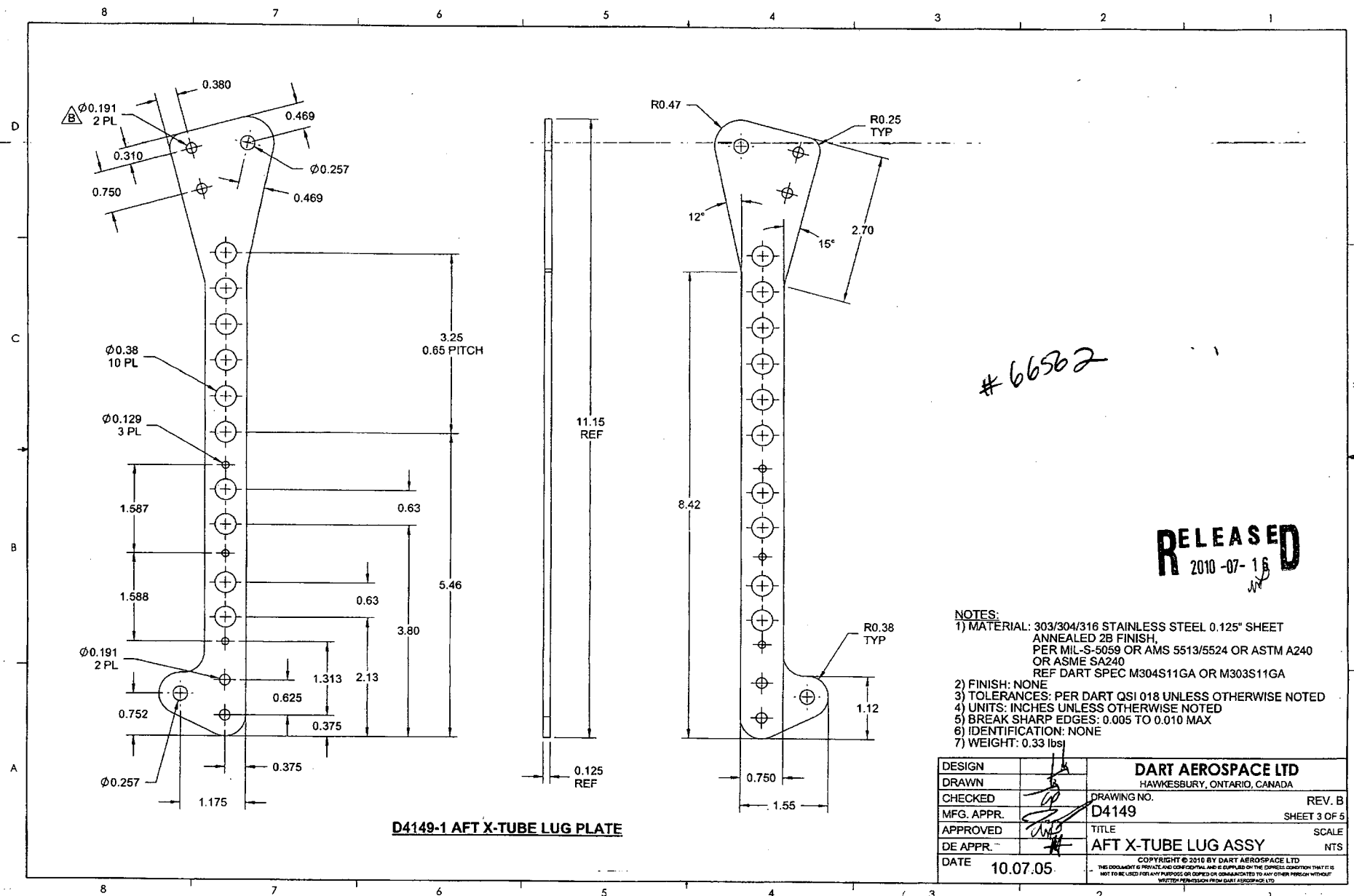
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